

Work Order ID 147327

Wednesday, June 08, 2016 2:53:11 PM

147327

Page 1

Item ID: D412-758-015 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: GPS Receiver Gimbal Mount
 Start Date: 5/31/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/8/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: JUN 10 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr		DAS						
IIN-D412-758	D		6						
		JUL 06 2016	9-89						CL 16-07-07
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-758-015 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
115	QC4- 100% Inspect kits for completeness	0.00							
115									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

JUL 21 2016

1 PC JUL 21 2016

DAS
27
9-89

JUL 21 2016



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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147327

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/31/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/8/2016 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00

120

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D412-758-015

Location: EG023

fg 023

DAS

27

9-89

21 2016

130

QC21- Final Inspection - Work Order Release

0.00

130

DAS

21

~~9-69~~

JUL 22 2016

QC

Memo

0.02

Quality Control

dm

16/07/21

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 147327

147327

Parent Item: D412-758-015

D412-758-015

Parent Item Name: GPS Receiver Gimbal Mount

Start Date: 5/31/2016

Required Date: 6/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.06.21 new issue DD verified by:EC
12.10.24 ECN 12-669 DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN525-10R9 Screw		Purchased	No			110	Each	181.0000	3	3			P<
AN525-10R9									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST329			181					
					m133990			181					
D3531-041 Top Mounted GPS Bracket		Manufactured	No			110	Each	0.0000	1	1			X 1 B146 985 PC
D3531-041									**				
D2464 Neoprene Seal (\$per foot)		Manufactured	No			110	f	783.8209	1.1	1.157895			PC
D2464									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST409			783.8208948					
					121946			783.820895					
D3525-1 Placard		Manufactured	No			110	Each	3.0000	1	1			PC
D3525-1									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST041			3					
					140393			3					

JUL 21 2016

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Parent Item: D412-758-015

D412-758-015

Parent Item Name: GPS Receiver Gimbal Mount

Start Date: 5/31/2016

Required Date: 6/8/2016

Start Qty: 1.00

Required Qty: 1.00

D3645-1 Manufactured No

110 Each

75.0000

4 4

D3645-1

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST048

75

123144

75

110 Each

84.0000

4 4

AN525-10R10

Purchased

No

AN525-10R10

Screw

DAS
27
9-89

Location

Loc Qty

Loc Code

ST329

84

M126175

84

110 Each

648.0000

4 4

NAS1149DN632J

Purchased

No

NAS1149DN632.J

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST264

648

m134370

648

110 Each

1,571.000

7 7

NAS1149D0363J

Purchased

No

NAS1149D0363.J

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

465

m134055

465

ST263

1106

m134606

106

m134676

1000

JUL 21 2016

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Parent Item: D412-758-015

D412-758-015

Parent Item Name: GPS Receiver Gimbal Mount

Start Date: 5/31/2016

Required Date: 6/8/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L06

Purchased

No

110

Each

159.0000

4

4

MS21042L06

Nut

**

PC



DAS
27
9-89

Location

Loc Qty

Loc Code

ST303

159

m134474

9

m134537

100

m134962

50

MS24693-S29

Purchased

No

110

Each

20.0000

4

4

MS24693-S29

SCREW

**

PC



DAS
27
9-89

Location

Loc Qty

Loc Code

ST286

20

m126400

20

RAM-B-201U-A

Manufactured

No

110

Each

9.0000

2

2

RAM-B-201U-A

SOCKET ARM, 1.75"

**

PC



DAS
27
9-89

Location

Loc Qty

Loc Code

ST570

9

144961

8

m134461

1

RAM-B-202U

Manufactured

No

110

Each

9.0000

2

2

RAM-B-202U

Round Plate Mount, Single 1" Ball

**

PC



DAS
27
9-89

Location

Loc Qty

Loc Code

ST571

9

144972

8

m134584

1

2

JUL 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																												
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																												
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																												
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																												
Past Expiry Date ☐	Manufacturing Process ☐																																																																																
Misidentified ☐	Past Due ☐																																																																																
OTHER :																																																																																	

Picklist Print

Wednesday, June 08, 2016 2:53:15 PM

Page 4

Work Order ID: 147327

147327

Parent Item: D412-758-015

D412-758-015

Parent Item Name: GPS Receiver Gimbal Mount

Start Date: 5/31/2016

Required Date: 6/8/2016

Start Qty: 1.00

Required Qty: 1.00

RAM-B-217U

Manufactured No

110

Each

6.0000

1

1

RAM-B-217U

ROUND PLATE MOUNT, DUAL 1" BALL

DAS
27
9-89

Location

Loc Qty

Loc Code

ST571

6

144973

4

m129792

2

MS21042L3

Purchased

No

110

Each

1,895.000

3

3

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

FP001

44

m133790

44

GA

269

m133790

3

m134360

266

OVER007

600

m134754

600

ST303

982

m134039

12

m134634

170

m134943

800

DAS
27
9-89

JUL 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

5.0 PARTS LIST

QTY -011	QTY -013	QTY -015	Part Number	Description
X			D412-758-011	Bottom Mounted GPS Receiver Gimbal Mount
	X		D412-758-013	Top Mounted GPS Receiver Gimbal Mount
		X	D412-758-015	GPSMAP Top Mounted GPS Receiver Gimbal Mount
1			D3514-041	Bottom Mounted Gimbal Assembly
	1		D3514-043	Top Mounted Gimbal Assembly
		1	D3531-041	Bracket Assy.
	2	2	D2464-0066	Neoprene Seal
1	1	1	D3525-1	Placard
1			D3527-1	Support Arm
1			D3530-1	Base Plate
1			D3530-3	Mounting Plate
1	1		D3534-1	Doubler
	4	4	D3645-1	Washer
		3	AN525-10R9	Screw
	4	4	AN525-10R10	Screw
3			AN526-632R7	Screw (or MS35206-229)
3		4	NAS1149DN632J	Washer (Alternate p/n AN960JD6)
2	4	7	NAS1149D0363J	Washer (Alternate p/n AN960JD10)
3		4	MS21042L06	Nut
1		3	MS21042L3	Nut
4	4		MS24693-S27	Screw
1			MS27039-1-09	Screw
		4	MS24693-S29	Screw
		2	RAM-B-201U-A	Socket Arm, 1.75"
		2	RAM-B-202U	Round Plate Mount, Single 1" Ball
		1	RAM-B-217U1	Round Plate Mount, Dual 1" Ball

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Revision: D

Date: 12.08.10